

\*Date: Friday, 22/05/2009 4:45:55 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : GASKET
<b>Job Number</b> : 48159	
<b>Estimate Number</b> : 12722	
<b>P.O. Number</b> :	<b>Part Number</b> : D353615
<b>This Issue</b> : 22/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3536 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 47711	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 29/05/2009 <b>Qty:</b> 12 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 09 05 25</u>	
<b>Comment</b> : Est Rev:A New Issue 07-02-14 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
-----	------------	----------------------



**Comment:** Qty.: 1.1122 sf(s)/Unit Total : 13.3462 sf(s)

NEOPRENE SHEET 0.063

Batch: 111469 B 968

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: A B 9-68

Prog Rev: 1

2-Deburr if necessary



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



B 9-68



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

508/06/08 (x12)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: Finishing

508/06/08 (x12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 22/05/2009 4:45:55 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 48159

Part Number: D353615

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/09 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 48159
<b>Description:</b> Gasket		<b>Part Number:</b> D3536-15
<b>Inspection Dwg:</b> D3536	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39.15	+			
35.65	+/-0.030	35.65	*			
33.65	+/-0.030	33.65	x			
30.15	+/-0.030	30.15	*			
24.90	+/-0.030	24.90	*			
19.65	+/-0.030	19.65	+			
14.40	+/-0.030	14.40	*			
9.15	+/-0.030	9.15	*			
5.65	+/-0.030	5.65	*			
3.90	+/-0.030	3.906	+			
8.00	+/-0.030	8.00	*			
16.00	+/-0.030	16.00	*			
24.00	+/-0.030	24.00	*			
0.30	+/-0.030	.305	*			
0.30	+/-0.030	.305	*			
1.89	+/-0.030	1.894	*			
Ø0.19	+0.005/-0.001	.19	*			

<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-6-08	<b>Date:</b> 09/06/08	<b>Date:</b>	N/A

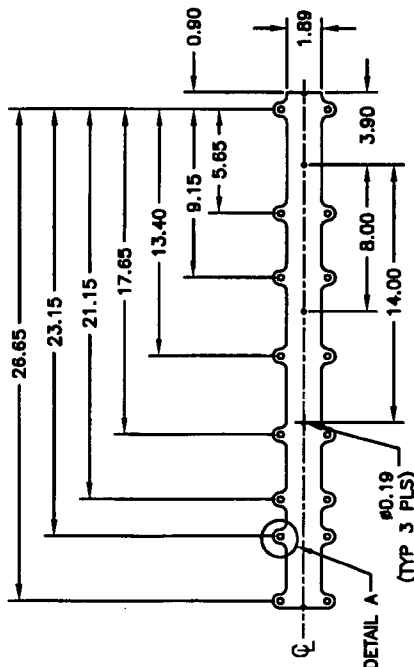
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

**DART**

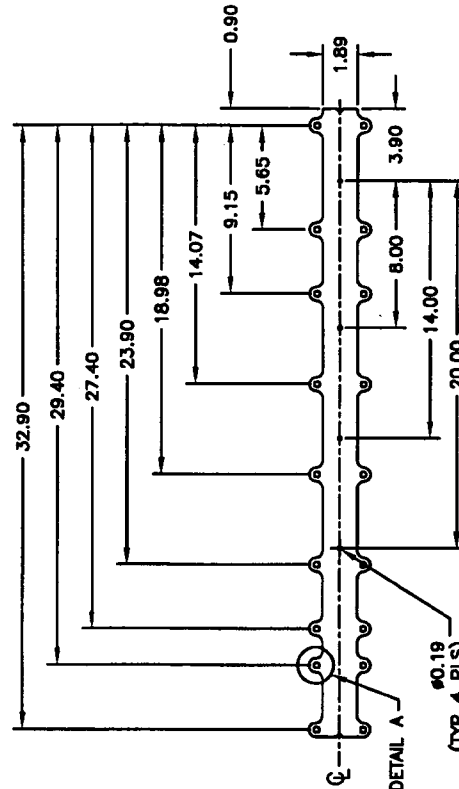
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CHECKED <b>PH</b>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3536</b>	REV. A SHEET 1 OF 6
DATE <b>06.10.25</b>		TITLE <b>GASKET</b>	SCALE <b>1:10</b>
<b>A</b>	<b>06.10.25</b>	<b>NEW ISSUE</b>	

RELEASED

09.03.12 *[Signature]*



**D3536-11 GASKET**



**D3536-13 GASKET**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. **148159**

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.083)
  - 2) FINISH: NONE
  - 3) PART IS SYMMETRICAL ABOUT Q
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
  - 7) SEE PAGE 6 FOR DETAILS AND SECTION

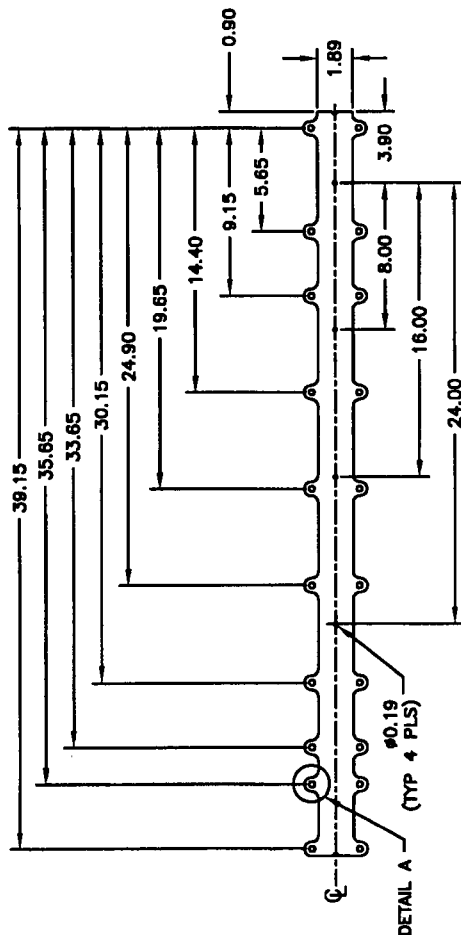
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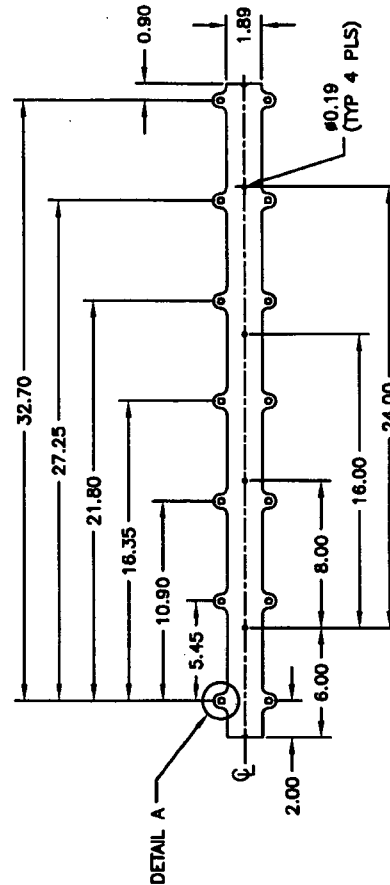
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DATE <b>06.10.25</b>	TITLE <b>GASKET</b>		SCALE 1:10

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07.02.12



**D3536-15 GASKET**



**D3536-21 GASKET**

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WITHOUT NOTICE  
WORK ORDER  
NO 48159

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 80 DUROMETER (REF DART SPEC. M-NEO80-S.063)
  - 2) FINISH: NONE
  - 3) PART IS SYMMETRICAL ABOUT C
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
  - 7) SEE PAGE 6 FOR DETAILS AND SECTION

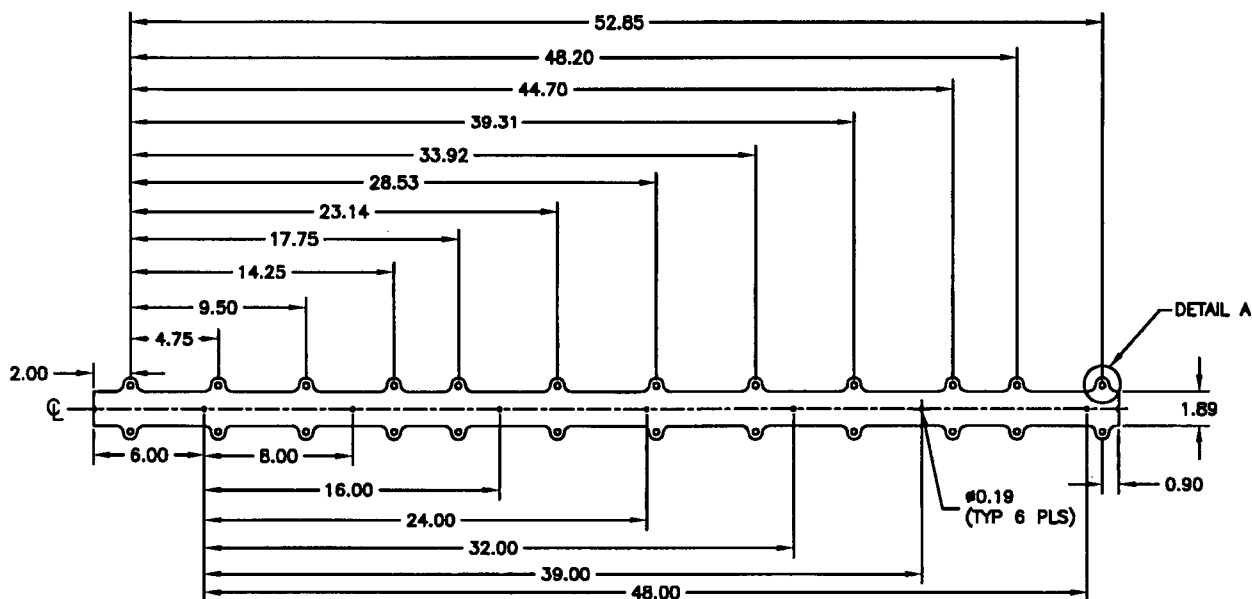
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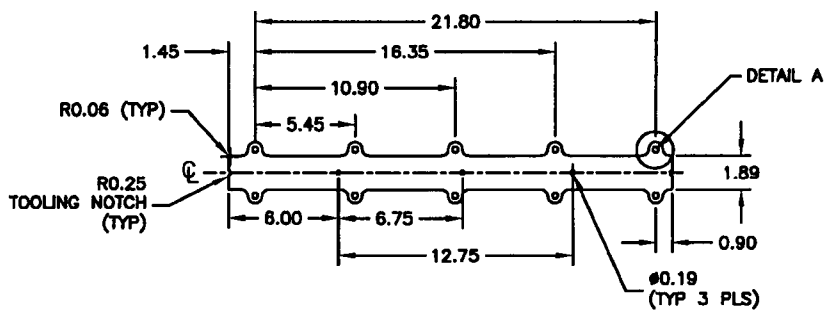
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 3 OF 6
		SCALE	1:10	

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070212 CH



**D3536-23 GASKET**



**D3536-25 GASKET**

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WITHOUT NOTICE  
W. J. R. J. J. J.  
NO. 178159

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

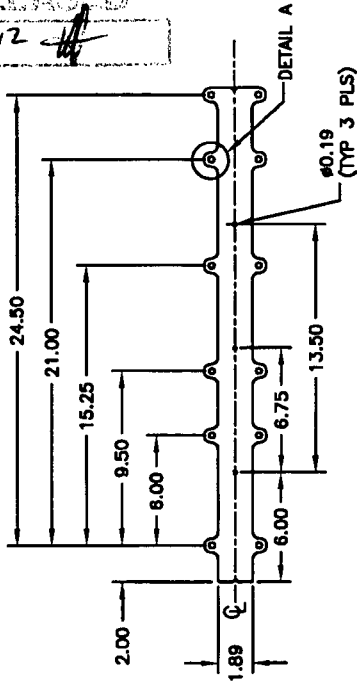


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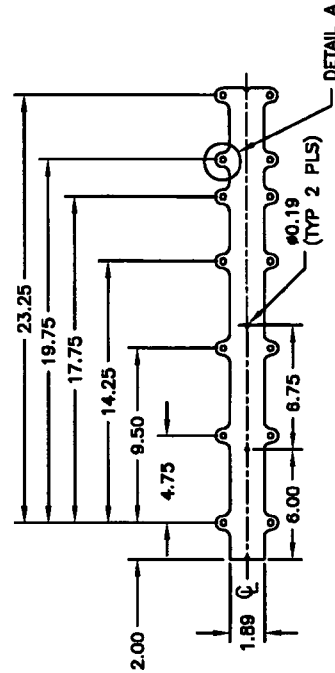
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DATE <b>06.10.25</b>		TITLE <b>GASKET</b>	SCALE 1:10

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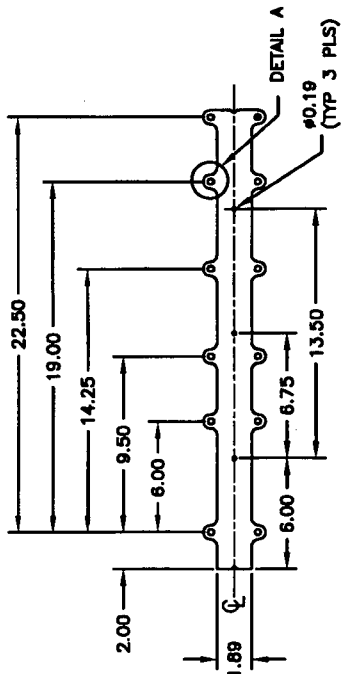
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**D3536-33 GASKET**



**D3536-35 GASKET**



**D3536-31 GASKET**

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WORK ORDER  
NO. 48159

- NOTES
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
  - 2) FINISH: NONE
  - 3) PART IS SYMMETRICAL ABOUT C
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
  - 7) SEE PAGE 6 FOR DETAILS AND SECTION

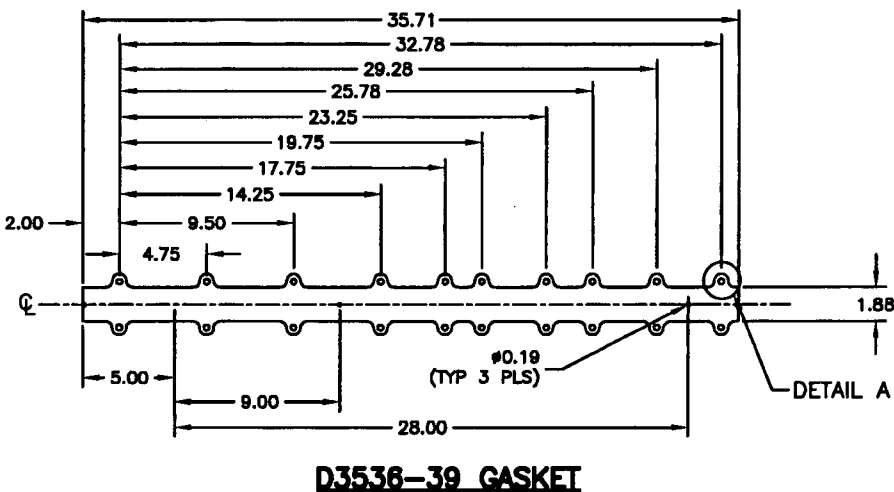
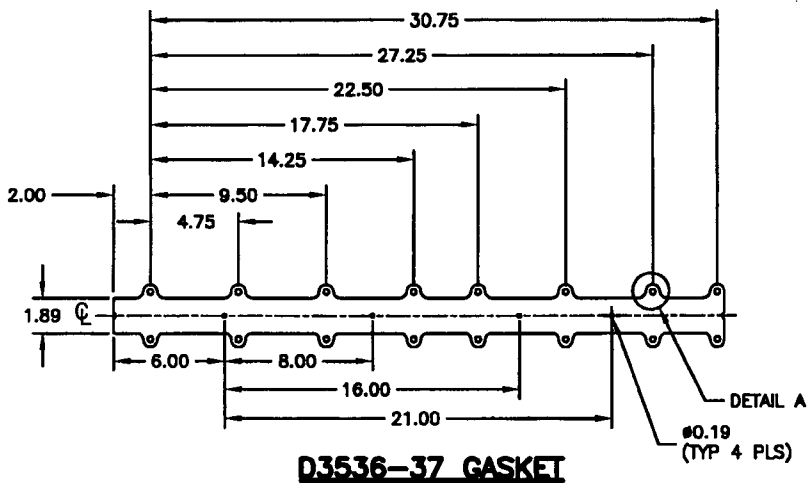
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		TITLE	GASKET	SHEET 5 OF 6
				SCALE
				1:10

07.02.02  
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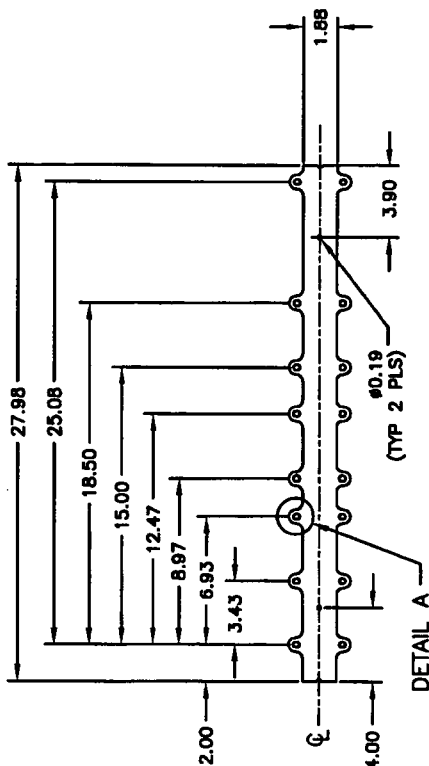
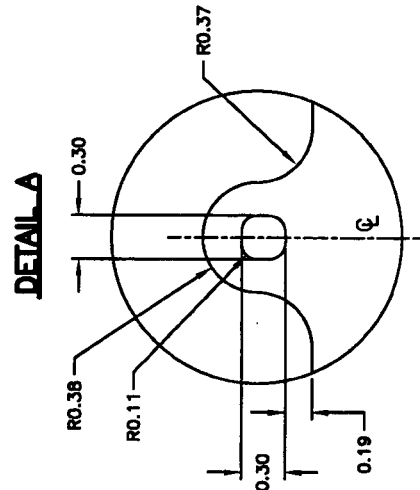
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



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DATE 06.10.25		TITLE GASKET	SCALE 1:10

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07.02.12 **[Signature]**



### D3536-41 GASKET

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE080-S.083)
  - 2) FINISH: NONE
  - 3) PART IS SYMMETRICAL ABOUT  $\phi$
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

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